

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-022703**Date Inspected:** 12-Apr-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See Below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector, Mike Hasler was present during the times noted above for observations and testing relative to the work being performed.

**Bay 1**

This QA inspector observed ZPMC in process of SMAW welding Bike Path Handrail sub-assemblies. ZPMC QC inspector Li Wei Lin was present at this time of this observation and informed this QA inspector of the work that is in process and identified Tian Lei as the CWI. It was stated that ZPMC had 3 welders and identified the welders by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

Weld- Bike Path Handrail Sub-assembly

WPS-B-P-2112

Welder- 215083, 221607, 062810

2F/SMAW

**Bay 4**

This QA inspector performed a random observation for the OBG. During the observation performed it was noted ZPMC was in process of welding on traveler rails. ZPMC QC inspector Li Wei Lin was present at this time of this observation and informed this QA inspector of the work that is in process and identified Tian Lei as the CWI. It was stated that ZPMC had 2 welders and identified the welders by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

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Weld- 3023TR1-001-001  
WPS-B-T-2231-ESAB  
Welder- 068206  
1G/FCAW/CJP

Weld- 3007TR2-001-041, 043  
WPS-B-T-2231-ESAB  
Welder- 068206  
1G/FCAW/CJP

Weld- 3009TR1-001-008  
WPS-B-T-2231-ESAB  
Welder- 068206  
2F/FCAW

Weld- 3007TR2-001-032, 033, 037  
WPS-B-T-2231-ESAB  
Welder- 068493  
1G/FCAW/CJP

Weld- 3023TR1-003-001  
WPS-B-T-2231-ESAB  
Welder- 068493  
1G/FCAW/CJP

### Bay 9

This QA inspector performed a random observation for the OBG. During the observation performed it was noted ZPMC was in process of welding. ZPMC CWI Chen Shi Gang was present at this time of this observation and informed this QA inspector of the work that is in process. It was stated that ZPMC had 4 welders and identified the welders by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

WR20568  
Weld- 3016TR1-001-001, 002  
WPS-345-FCAW-1G-ESAB-Repair  
Welder- 059421  
1G/FCAW/CJP

Weld- X5001B-002-001  
WPS-B-T-2232-ESAB  
Welder- 059403  
2G/FCAW/CJP

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Weld- 3013TR2-002-003  
WPS-B-T-2231-ESAB  
Welder- 059378  
1G/FCAW/CJP

Weld- 3013TR1-002-002  
WPS-B-T-2231-ESAB  
Welder- 059443  
1G/FCAW/CJP

### Bay 10

This QA inspector performed a random observation for the OBG. During the observation performed it was noted ZPMC was in process of welding. ZPMC QC inspector Yu Zhi Lai was present at this time of this observation and informed this QA inspector of the work that is in process and identified Shi Yu as the CWI. It was stated that ZPMC had 7 welders and identified the welder by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

Weld- 31TR1-001-002  
WPS-B-P-2212-TC-U5b  
Welder- 040365  
2G/SMAW/CJP

Weld- 31TR1-001-004  
WPS-B-T-2232-ESAB  
Welder- 052075  
2G/FCAW/CJP

Weld- 31TR1-001-010  
WPS-B-T-2132-ESAB  
Welder- 054069  
2F/FCAW

Weld- 31TR1-001-013  
WPS-B-P-2212-TC-U5b  
Welder- 050038  
2G/SMAW/CJP

Weld- BK009A1-001  
WPS-B-P-2213-TC-U5b  
Welder- 040582, 057200, 053829  
3G/SMAW/CJP

### UT Inspection

This Caltrans QA inspector received ZPMC non-destructive test (NDT) Inspection Notification, Doc. #08808 from

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ZPMC for QAUT verification for traveler rail in Bay 10. This QA inspector performed ultrasonic test (UT) verification for Item 1 & 2, after ZPMC had performed their UT inspection of the following locations.

Item 1

25TR1-001-002, 013, 016

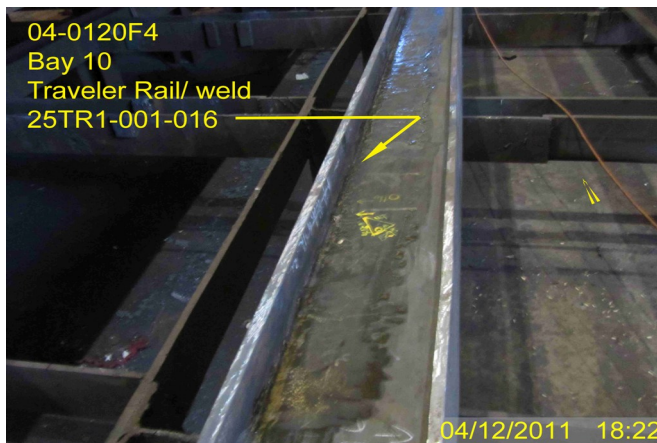
Item 2

25TR1-001-004, 008, 011

At the time of the verification it was noted that the above component appeared to be within compliance of the contract documents. See Caltrans Ultrasonic Test Report (TL6027), dated 04-12-2011 for additional information.

The following digital picture illustrates traveler rail QAUT verification for 25TR1-001-016 weld.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



### Summary of Conversations:

“As noted within the contents of this report.”

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey 1500026784, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Hasler, Mike	Quality Assurance Inspector
<b>Reviewed By:</b>	Riley, Ken	QA Reviewer

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